











Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT CROSSTUBE
Job Number	: 29478		
Estimate Number	: 10377		
P.O. Number	: N/A	Part Number	: D2890
This Issue	: 11/16/2006 S.O. No. : N/A	Drawing Number	: D2890 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 29477	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 12/10/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	1
Comment	: Est. ID 05.03.21 Removed Bending procedures KJ/JLM	Um:	Each

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6008180	Crosstube extrusion
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part # Description Batch 1 • D6008-180 Crosstube extrusion <i>B22534 DP 6-11-21</i>		
2.0	BENDING	BENDING MACHINE
		
Comment: BENDING MACHINE 1-Bend D2890 as per Dwg D2890 and Folio FT002 <i>DP 6-11-28</i>		
3.0	QC6	DIMENSIONAL CHECK
		
Comment: DIMENSIONAL CHECK <i>See 12-06 ①</i>		
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		
Comment: LANDING GEAR RESOURCE 1 1-Deburr and Polish <i>see w/o 79702</i>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/30

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/16/2006 4:25:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 29478

Part Number: D2890

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

See also 29702

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

for W/O 29702

8.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

07/01/30

Job Completion



u 07-01-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

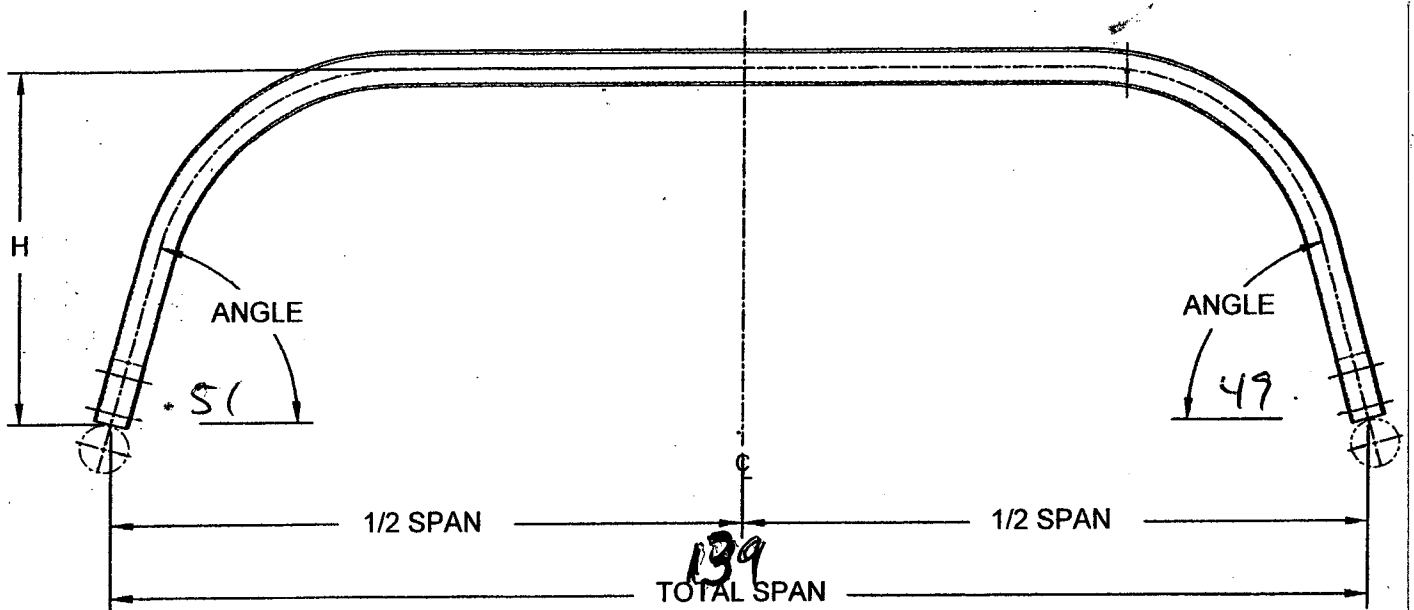
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Crosstube Bend Dimension Sheet



See w/o 205-596-103
B29702

PART NUMBER: 2890

BATCH NUMBER: 29478

DRAWING: 2890 REVISION: B

H: N/A

1/2 SPAN: N/A

TOTAL SPAN: 138.8 ± .25

ANGLE: 50 ± 2

QC 15: J

DATE: 06-12-06

QTY: 1